

Work Order ID 69147

Tuesday, May 03, 2011 11:38:09 AM



Page 1

Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Item Name: Skidtube RH

Stop



Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 1053

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

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0.00

0.00

100



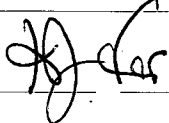
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Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

 BG 11-9-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
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Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10- Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

11/08/30

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: M117884 86 11/08/30

12-Grind welds flush as per Dwg D2750

86 11/08/31

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

8 11/08/31

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 11/08/31

86

W/O:		WORK ORDER CHANGES					
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Item Name: Skidtube RH

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

WH
24/08/31

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1

2

BEH/08/31

W/O:		WORK ORDER CHANGES					
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Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750								
	2-Open holes section BC-BC 0.3125" (4 per side)								
	3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)								
	5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.								
	6-Bond web D2739 in place as per QSI 015								
	A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Sikaflex-291 batch: <u>M118393</u>								
	exp. date: <u>12/04/05</u> <i>OK 11/08/31</i>								
	7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 11)								
	A/R <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> Aluminum Rod batch: <u>M117884 / M118736</u> <i>BE 11/07/07</i>								
	8-Grind welds flush as per Dwg D2750								
	9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750								
	10-Deburr holes								

OK 11/08/31

BE 11/09/08

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Accept



Setup Start



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Stop



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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Sulorlos

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulorlos

④

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

HX Ø M-11/09/08

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 7:30

OVEN TEMPERATURE: 320 °F

FINISH TIME: 8:00

0.00

H. J. M. 11/09/12

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

1 of 11 11/09/12

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Install inserts as per dwg D2750

2-assemble o-ring as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: M110348

3-Assemble tube hardware as per dwg D2750 sikaflex batch: M118393 12/01

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: M118393

EXP DATE: 12/01

7-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M110348

8-Coat all exposed fasteners with "LPS Procyon" batch: M114596

1 0 40 4/09/11

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SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

8/10/12

[illegible]

Memo

0.00

0.00

[REDACTED]

Packaging

Memo

Packaging

0.00

11/9/13

0.00

[illegible]

QC

Memo

0.00

6/10/15

⑦

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 10

Accept

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100	101	102	103	104	105	106	107	108	109	110	111	112	113	114	115	116	117	118	119	120	121	122	123	124	125	126	127	128	129	130	131	132	133	134	135	136	137	138	139	140	141	142	143	144	145	146	147	148	149	150	151	152	153	154	155	156	157	158	159	160	161	162	163	164	165	166	167	168	169	170	171	172	173	174	175	176	177	178	179	180	181	182	183	184	185	186	187	188	189	190	191	192	193	194	195	196	197	198	199	200	201	202	203	204	205	206	207	208	209	210	211	212	213	214	215	216	217	218	219	220	221	222	223	224	225	226	227	228	229	230	231	232	233	234	235	236	237	238	239	240	241	242	243	244	245	246	247	248	249	250	251	252	253	254	255	256	257	258	259	260	261	262	263	264	265	266	267	268	269	270	271	272	273	274	275	276	277	278	279	280	281	282	283	284	285	286	287	288	289	290	291	292	293	294	295	296	297	298	299	300	301	302	303	304	305	306	307	308	309	310	311	312	313	314	315	316	317	318	319	320	321	322	323	324	325	326	327	328	329	330	331	332	333	334	335	336	337	338	339	340	341	342	343	344	345	346	347	348	349	350	351	352	353	354	355	356	357	358	359	360	361	362	363	364	365	366	367	368	369	370	371	372	373	374	375	376	377	378	379	380	381	382	383	384	385	386	387	388	389	390	391	392	393	394	395	396	397	398	399	400	401	402	403	404	405	406	407	408	409	410	411	412	413	414	415	416	417	418	419	420	421	422	423	424	425	426	427	428	429	430	431	432	433	434	435	436	437	438	439	440	441	442	443	444	445	446	447	448	449	450	451	452	453	454	455	456	457	458	459	460	461	462	463	464	465	466
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Setup Start[illegible]

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

Run Start

[illegible]

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

[illegible]

Packaging

0.00

Packaging

Memo

Packaging

Package as per PPP D350-636-014

I

280

QC21- Final Inspection - Work Order Release

0.00




Memo

0.00

QC

Quality Control

11/9/15 
MF 11-09-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 11:38:15 AM

Page 1

Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ
 IPP Rev:I 05.12.08 Rearranged procedure steps EC
 IPP Rev:J 06.03.30 Per rev. D EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT Extrusion Bent		Manufactured	No			110	Each	23.0000	1	1		11/08/30	
<div>Location</div> <div>72153</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>LG</div> <div>23</div> <div>66874</div> <div>1</div> <div>66875</div> <div>8</div> <div>68137</div> <div>10</div> <div>68138</div> <div>4</div>													
D2739 350 I Beam		Manufactured	No			160	Each	14.0000	1	1			
<div>Location</div> <div>70823</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>LG</div> <div>14</div> <div>67785</div> <div>2</div> <div>68285</div> <div>6</div> <div>68286</div> <div>6</div>													
D2743 Crossbolt Spacer		Manufactured	No			160	Each	187.0000	8	8			
<div>Location</div> <div>LG001</div> <div>Loc Qty</div> <div>Loc Code</div>													
<div>67766</div> <div>123</div> <div>68251</div> <div>64</div>													

DL
 11/09/01
 BB 11/09/07
 871839 *8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 11:38:15 AM

Page 2

Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2744 Manufactured No 160 Each 37.0000 1 1
Cap

BE 11/08/29
B 70 881 ✓

Location	Loc Qty	Loc Code
LG002	37	
62715	8	
65086	29	

D3490-1 Manufactured No 160 Each 93.0000 4 4
Cross Bolt Spacer

BE 11/08/07
B 69823 x4

Location	Loc Qty	Loc Code
LG	91	
67773	31	
68105	60	
LG001	2	
62450	2	

D3490-5 Manufactured No 160 Each 74.0000 4 4
Cross Bolt Spacer

BE 11/09/07

Location	Loc Qty	Loc Code
LG001	74	
46490	18	
59230	56	

ALS4-1032-225 Purchased No 230 Each 1,069.000 38 38
Insert

M 11/09/19

Location	Loc Qty	Loc Code
FP-B	28	
110768	28	
ST282	1041	
110768	1041	

M 111581 V38

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,332.000

34

34



11/09/12

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1325

115422

49

116419

376

116549

100

117343

500

117508

300

x34

AN3C6A

Purchased

No

230

Each

300.0000

4

4



11/09/12

BOLT

Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

299

111982

2

116419

47

116549

50

116704

100

117514

100

1117872

1117688

x1

x3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Tuesday, May 03, 2011 11:38:16 AM

Work Order ID: 69147

Parent Item: D350-636-014


Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00


Required Qty: 1.00

AN6C44A Purchased No 230 Each 86.0000 4 4

 BOLT

Location	Loc Qty	Loc Code
FG	2	1118112
103964	2	1117950
ST344	84	1118332
116874	4	
117407	80	

11/09/12


x2
x1
x1

AN8C35A Purchased No 230 Each 70.0000 1 1

 BOLT


Location	Loc Qty	Loc Code
FP	40	
117511	40	
FP-A	30	
115960	7	
116874	23	

11/09/12

x1

AN960C10L NAS1149C0332 Purchased No 230 Each 0.0000 38 38

 washer

1118354 (13%) 11/09/12

AN960C816L Purchased No 230 Each 0.0000 1 1

 WASHER

x NAS1149C0832 R / 11/11/15 *

(x1) 11/09/12

Tuesday, May 03, 2011 11:38:16 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

214.0000 8 8



Bushing



xl u109112

Location

Loc Qty

Loc Code

FP-A

214

B69529

x8

67764

13

68248

201

D3488-042

Manufactured No

230 Each

12.0000 1 1



xl u109112

Blade Fitting Assembly, RH

Location

Loc Qty

Loc Code

FP008

12

B68109

xl

62003

4

65099

8

D3492-1

Manufactured No

230 Each

0.0000 8 8



(x8) xl u109112

Plug

D3492-5

Manufactured No

230 Each

0.0000 8 8



(x8) xl u109112

Plug

D3535-25

Manufactured No

230 Each

18.0000 1 1



xl u109112

Wearshoe

Location

Loc Qty

Loc Code

FP018

18

B69743

xl

62233

1

65167

6

68353

11

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 69147

Parent Item: D350-636-014


Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011


Start Qty: 1.00

Required Qty: 1.00

D3536-25 Manufactured No 230 Each 37.0000 1 1

 Gasket


Location	Loc Qty	Loc Code
FP012	37	B70780
65903	11	
68351	26	

xl 11/09/12

D3537-1 Manufactured No 230 Each 39.0000 3 3

 Wearpad


Location	Loc Qty	Loc Code
FP017	39	
63313	2	
66135	33	B70687
66935	4	

xl 11/09/12

D3631-1 Manufactured No 230 Each 500.0000 8 8

 Washer

Location	Loc Qty	Loc Code
ST072	500	
68062	500	

xl 11/09/12

D3672-1 Manufactured No 230 Each 1,379.000 8 8

 Phenolic Washer

Location	Loc Qty	Loc Code
FP-A	29	
52505	29	
ST074	1350	
64177	850	
66821	500	

xl 11/09/12 PTO=>

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Page 6

W/O: 69147		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/09/12	230	Assemble with "NAS 1515 H361 K113362 washers Permanent change!	el el	11/09/12 11.09.16	x4	W	S 11/09/16

Part No: D350-636-014 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 69147

Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1	Manufactured	No	230	Each	8.0000	1	1
							<u>u109/12</u>
Wearplate							

Location

Loc Qty

Loc Code

FP017



8

B69287

u1

62239

8

D3793-1	Manufactured	No	230	Each	15.0000	1	1
							<u>u109/12</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP018



15

B70781

u1

61710

1

D3793-3	Manufactured	No	230	Each	23.0000	1	1
							<u>u109/12</u>
Wearshoe							

Location

Loc Qty

Loc Code

FP018

13

68356

13

FP019



10

B70813

u1

64447

10

D3794-1	Manufactured	No	230	Each	33.0000	1	1
							<u>u109/12</u>
Gasket							

Location

Loc Qty

Loc Code

FP010

33

B70779

u1

39279

1

39421

1

61704

5

68355

26

Tuesday, May 03, 2011 11:38:17 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

35.0000

1

1



Gasket



11/09/12

Location

Loc Qty

Loc Code

FP010

26

370812

68357

26

x1

FP018

9

39422

1

61712

8

MS21043-6

Purchased No

230 Each

527.0000

4

4



NUT



11/09/12

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314

44

ST301

463

x4

112314

463

MS21083C8

Purchased No

230 Each

91.0000

1

1



NUT



11/09/12

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

1118073

115884

0

x1

117291

40

117423

50

Tuesday, May 03, 2011 11:38:17 AM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 11:38:17 AM

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Work Order ID: 69147

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

216.0000

8

8



O-RING



11/09/12

Location

Loc Qty

Loc Code

FP002

216

106099

111

114220

105

x3

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING



11/09/12

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

11/18/12

x8

AN8C21A

Purchased

No

250

Each

78.0000

2

2



BOLT



11/17/12

Location

Loc Qty

Loc Code

ST345

78

116381

28

117562

50

AN960JD816

Purchased

No

250

Each

45.0000

2

2



1/2" washer, Alum



11/18/12 11/9/13

NAS1149 108633

Location

Loc Qty

Loc Code

FP-A

45

106043

45

Tuesday, May 03, 2011 11:38:17 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 03, 2011 11:36:36 AM

Work Order ID: 69146

Parent Item: D350-636-014


Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

 Blade, 350 Skidtube

Manufactured No 250 Each 45.0000

1 1


B69133

Location Loc Qty Loc Code

ST466 45
 61341 7
 63589 38

Manufactured No 250 Each 33.0000

2 2


B70697

Location Loc Qty Loc Code

ST062 33
 66975 33

Purchased No 250 Each 91.0000

2 2


M118354 11/9/13

MS21083C8

 NUT

Location Loc Qty Loc Code

FP-B 1
 115884 1
 ST303 90
 115884 0
 117291 40
 117423 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

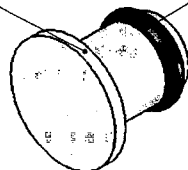
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09147

pl 17-03-3

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

~~UNDER REVIEW~~

OK - JSS 08.11.12

DEO ATTACHED

RELEASED

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3492	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PLUG	2:1
DATE	07.10.05	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

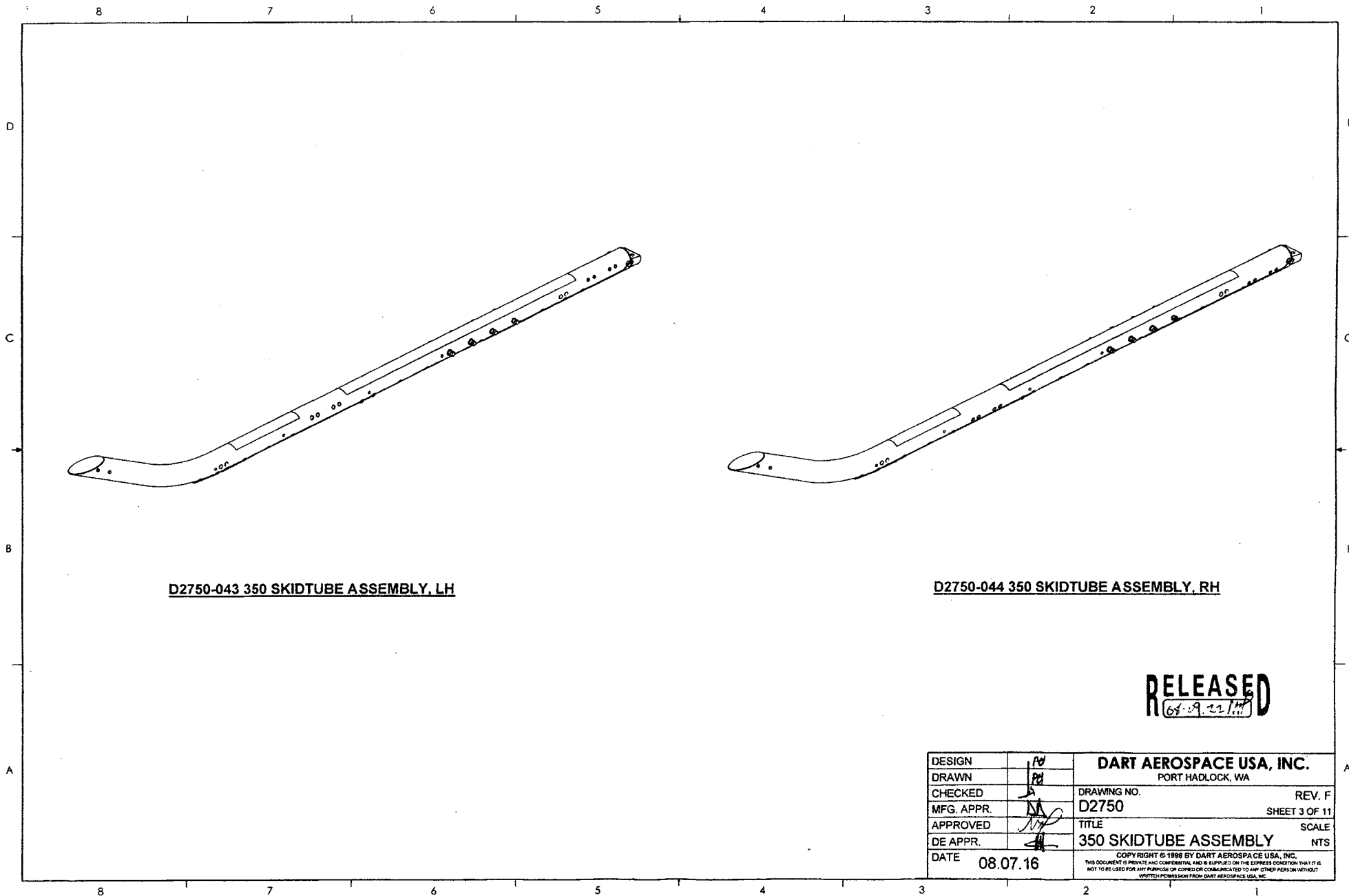
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL Δ
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL Δ

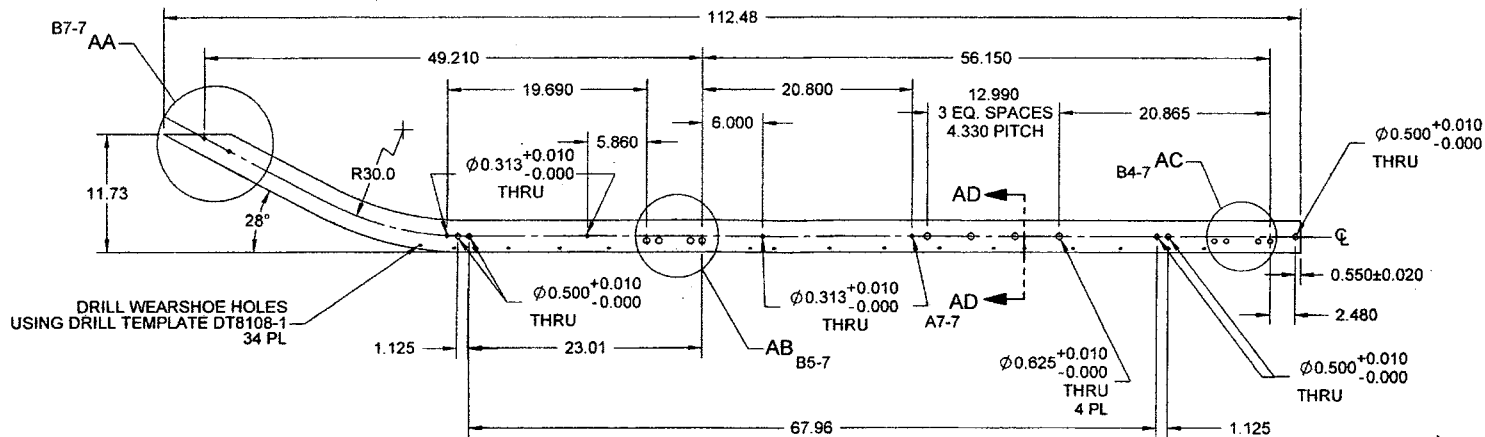
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68 09 22 14

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3535-13/-35 (ZN B8-1); ADD D3781-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24684-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC.	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. F
MFG. APPR.	AS	D2750	SHEET 1 OF 11
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

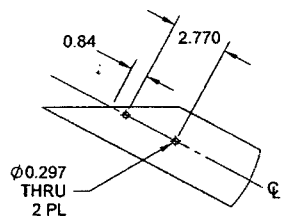


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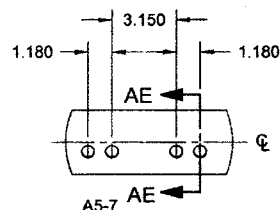
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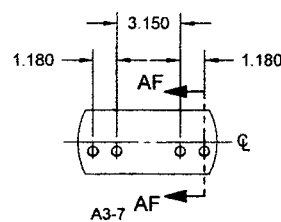
D2750-4 RH SKIDTUBE



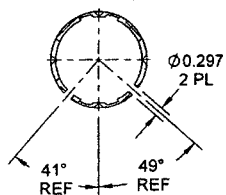
DETAIL AA
SCALE 2X



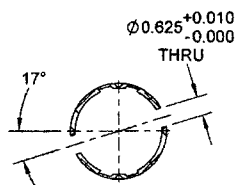
DETAIL AB
SCALE 2X



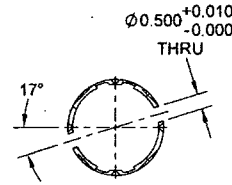
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL

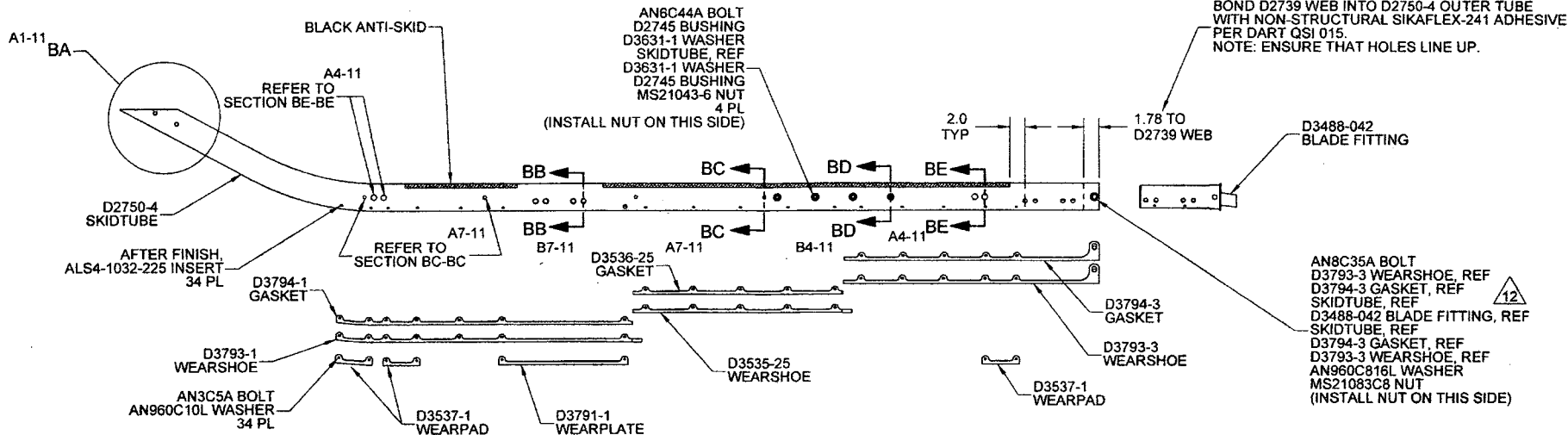


SECTION AF-AF
SCALE 3X, 4 PL

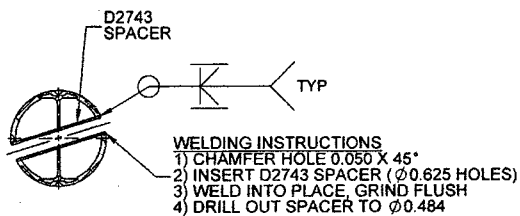
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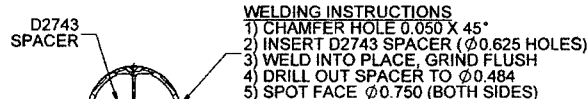
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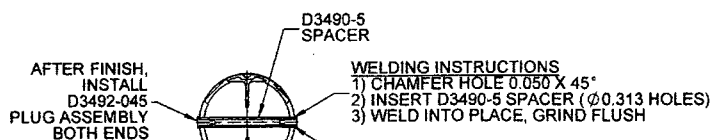
D2750-044 350 SKIDTUBE ASSEMBLY, RH



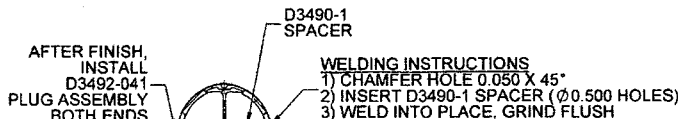
SECTION BB-BB SCALE 3X, 4 PL



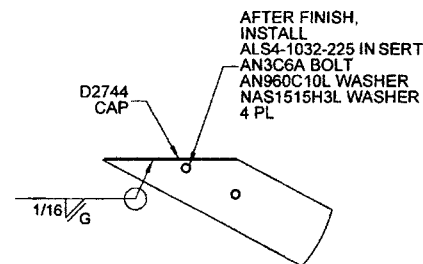
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

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MFG. APPR.			SHEET 11 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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RELEASED

NO. 265

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 714270
Part number: J 350 636 015
Description: 350
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier: Sal Luy Date of Test Coupon 11.09.06
Welder: Barclay Elliott Date of Test Coupon 11.09.06

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries